

Work Order ID 87023

Monday, July 09, 2012 9:14:52 PM

87023

Page 1

Item ID: D4522-049

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Base, Latch Shaft

Start Date: 7/10/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4522	B

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK AT 1.750"

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB103

FOLIO REV:

DWG REV:

DEBURR

INSERT Helicorl.
AS PER DWG

12.07.16

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		24 12-7-15		2			
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	DAS 14 12/07/16			2	0		
160 *160* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00	SEA 17			2A			SD 12-7-16

Work Order ID 87023***87023***

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Revision ID:

Stop ***NS2***

Item Name: Base, Latch Shaft

Start Date: 7/10/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21 - Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/7/23 *[Signature]*
MF
12-07-17

Picklist Print

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Page 1

Work Order ID: 87023

Parent Item: D4522-049

Parent Item Name: Base, Latch Shaft

Start Date: 7/10/2012

Required Date: 7/19/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-02-18 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B2.000X02.000
6061-T6 Bar 2.00 x 2.00

Purchased

No

f 12.2570

0.29

B.A 12/07/10

Location

Loc Qty

Loc Code

MAT009

12.257

→ 113123

1.977

119801

9.09

13085

1.19

0.3016 ft

MS21209-C0820

Purchased

No

Each 10.0000

2

Threaded Insert, 8-32 UNC x 0.33 LG

Location

Loc Qty

Loc Code

ST305

10

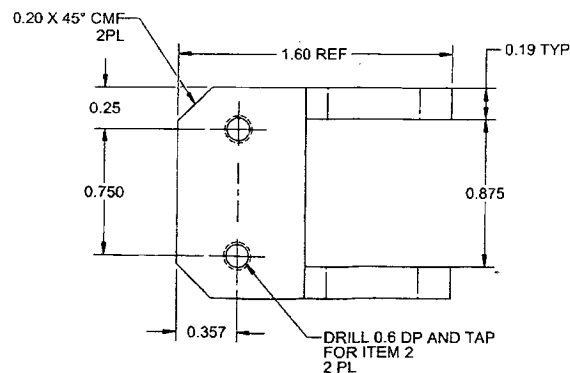
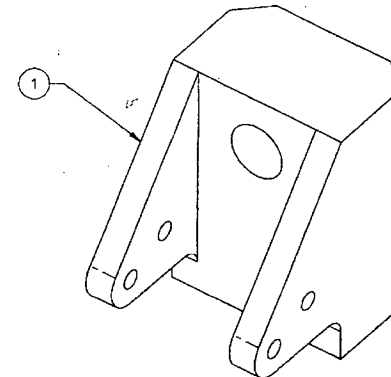
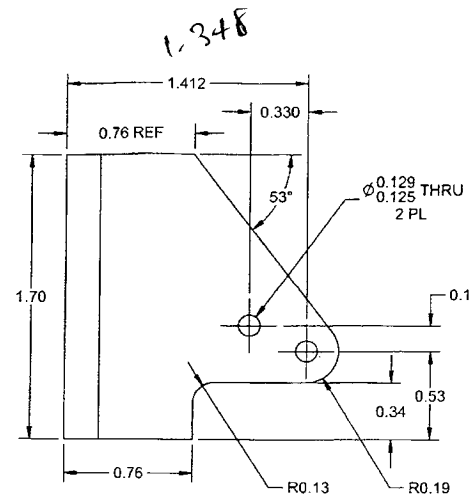
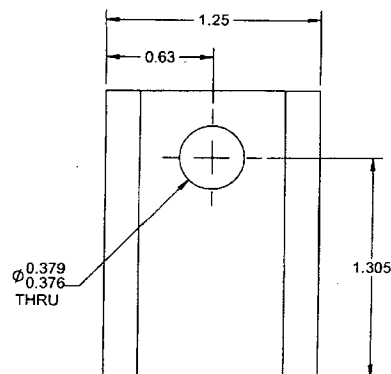
120593 ✓

10

x 2

2 12-7-15



ITEM	QTY	P/N	DESCRIPTION
	X	D4522-049	BASE, LATCH SHAFT
1	1	D4522-7	BASE, LATCH SHAFT
2	2	MS21209-C0820	THREADED INSERT, 8-32 UNC X 0.33 LG



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR
AMS4117/4128/4115/4116 OR QQ-A-200/8 OR
AMS 4160 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.16 lbs

D4522-049 BASE, LATCH SHAFT

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 11 OF 23
APPROVED	JNT	TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.04.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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RELEASED
2012-06-13

0875

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD.		Work Order: 87023
Description: LATCH SHAFT		Part Number: 04522-019
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/- .030	1.250	/		29.02	
.63	+/- .030	.626	/			
.379	+/- .030	.376	/			
1.412	+/- .010	1.419	/			
.76 REF	+/- .030	.761	/			
.330	+/- .010	.331	/			
53°	+/- 1/2°	53°	/			
1.70	+/- .030	1.699	/			
.129 REF	+/- .030	.125	/			
.152	+/- .010	.152	/			
.53	+/- .030	.525	/			
.34	+/- .030	.339	/			
.76	+/- .030	.762	/			
R. 13	+/- .030	.125	/			
R. 19	+/- .030	.190	/			
.20x.45	+/- .030	.20	/			
1.60 REF	+/- .030	1.605	/			
.19 REF	+/- .030	.186	/			
.25	+/- .030	.250	/			
.750	+/- .010	.750	/			
.357	+/- .010	.358	/			
.875	+/- .010	.877	/			
.6 REF	+/- .060	.602	/			

Measured by: 29	Audited by: DAS 14	Preliminary Approval:
Date: 12-7-15	Date: 12/08/16	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15